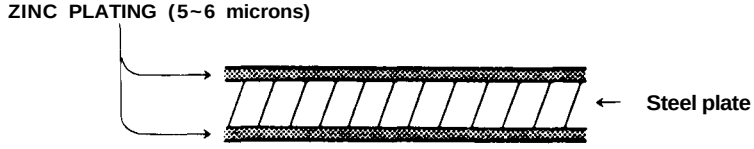
General Information

Zinc-plated Steel Plate Repair

The zinc-plated steel plate used in some panels of the Accord requires different repair techniques than ordinary steel plate. Refer to "Body Construction" (see pages 4-2, 4-3) for the location of the zinc-plated panels.



1. Before spot welding the zinc-plated steel plate, remove the paint from both sides of the flange to be welded. Apply sealer to the flange after welding.

   ⚠WARNING **To prevent eye injury, wear goggles or safety glasses whenever sanding, cutting, or grinding.**

   NOTE: Seal the sanded surfaces thoroughly to prevent rust.

2. The electric continuity properties of zinc-plated steel plate is different from ordinary steel plate. When spot welding, increase the current by 10-20%, or increase the resistance welding time.
   Increase the number of weld spots by 10-20% also.

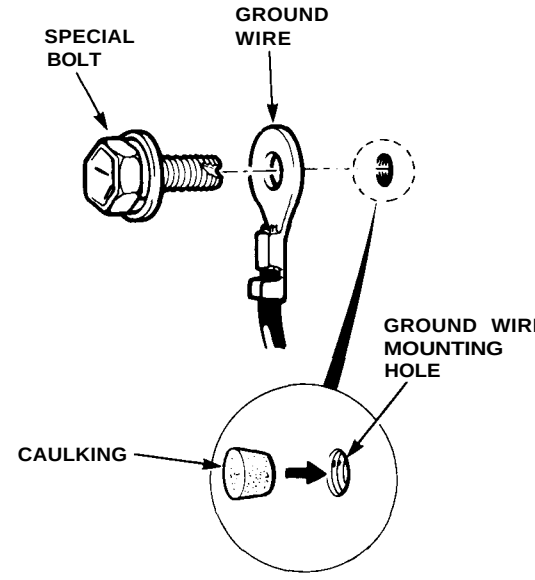
   NOTE: The MIG welding procedures for zinc-plated steel plate are the same as for ordinary steel plate.

   ⚠WARNING **To prevent eye injury and burns when welding, wear an approved welding helmet, gloves and safety shoes.**

3. Before applying putty or body filler to the zinc-plated steel plate, sand the zinc plating thoroughly to promote adhesion and to prevent blistering.

   NOTE:
   - Use only epoxy-based putties and fillers on zinc-plated steel plate.
   - Follow the manufacturer's specification.

4. When performing paint work, apply caulking to the ground wire mounting position to mask the body.



Avoid puttying as much as possible when repairing a new vehicle. Use alternative methods as possible.

⚠ WARNING

- **Most paints contain substances that are harmful if inhaled or swallowed. Read the paint label before opening the container. Spray paint only in a well ventilated area.**
- **Cover spilled paint with sand, or wipe it up at once.**
- **Wear an approved respirator, gloves, eye protection and appropriate clothing when painting. Avoid contact with skin.**
- **If paint gets in your mouth or on your skin, rinse or wash thoroughly with water. If paint gets in your eyes, flush with water and get prompt medical attention.**
- **Paint is flammable. Store it in a safe place, and keep it away from sparks, flames, or cigarettes.**

Operation	Tools/Materials	Procedure	Remarks
1. Prep the repair area.	Double-action sander, #80 sandpaper.	Sand the area with a double-action sander and #80 sandpaper. Clean with wax and grease remover.	
2. Apply putty. NOTE: Putty can be applied after priming as described in step 4.	Epoxy-based putty: Mix the putty and hardener according to the manufacturer's directions. Polyester resin putty. Body filler.	Apply in several thin coats if necessary. Try to avoid leaving pinholes in the putty. Follow the manufacturer's recommendations for preparation.	
3. Sand and clean the puttied area.	Double-action sander, orbital sander, hand sanding file, #80, #120, #240 sandpaper, wax and grease remover, shop towels.	Rough-sand the area with a double-action sander and #80 sandpaper, then sand with #120 sandpaper. Featheredge with #240 sandpaper. Clean with wax and grease remover.	
4. Coat with primer. NOTE: Apply to bare sheet metal and puttied area.	Epoxy-based primer and hardener, epoxy thinner: Mix and thin the primer according to the manufacturer's directions.	Apply 2–4 coats, allowing sufficient flash time between coats. Force dry at 140–158°F (60–70°C) for at least 30 minutes.	Spray to a thickness of 30–35 microns
5. Sand and clean the whole area.	Double-action sander, #300, #400 sandpaper, wax and grease remover, shop towels.	Sand the repair area by hand with #300, #400 sandpaper. Blow off with compressed air. Clean with wax and grease remover.	
6. Apply intermediate coat to the whole area to be repainted.	Polyester/urethane resin primer/surfacer or top-coat enamel: Mix and thin the primer according to the manufacturer's directions.	Apply 2–4 coats, allowing sufficient flash time between coats. Force dry at 140–158°F (60–70°C) for at least 30 minutes.	Spray to a thickness of 30–35 microns
7. Sand and clean the whole area to be repainted.	Hand sanding file, double-action sander, #400, #600 sandpaper, wax and grease remover, shop towels.	Sand the repair area by hand with #400 sandpaper until it's level. Sand the whole area to repainted with #400–600 sandpaper. Clean with wax and grease remover.	
8. Top-coat the whole area to repainted.	Acrylic urethane resin top coat paint, hardener, and thinner: Mix and thin the paint according to the manufacturer's directions.	Apply 2–4 coats allowing sufficient flash time between coats. Force dry at 140–158°F (60–70°C) for at least 30 minutes.	Spray to a thickness of 40–50 microns